




Work Order ID 62395


Wednesday, September 29, 2010 1:25:42 PM

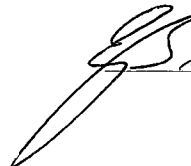
Page 1


Item ID:	D3278-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Support Assembly				Stop	
Start Date:	9/29/2010	Start Qty:	30.00		Cust Item ID:	
Required Date:	10/21/2010	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-9-25	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								


100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Rivet spacers with support as per Dwg D3278.								

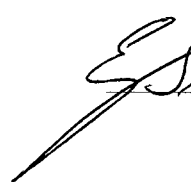
 10/10/06 (30)

110	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

81010106

counts
(+30)

120		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble support as per Dwg D3278. <input type="checkbox"/> ***DO NOT TIGHTEN BOLTS*** <input type="checkbox"/> Identify as D3278-041								

 10/10/07 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Item ID: D3278-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Support Assembly
Start Date: 9/29/2010 Start Qty: 30.00  Cust Item ID:
Required Date: 10/21/2010 Req'd Qty: 30.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8/10/10/02</i>		<i>counted</i> <i>(30)</i>			
140  Packaging Packaging	Identify as per dwg & Stock Location: <i>471</i> Memo	0.00 0.00				<i>CC10/10/08</i>		<i>(30)</i>	
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>10/10/12</i> <i>10/10/12</i> <i>(30)</i>	

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62395



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 9/29/2010

Required Date: 10/21/2010

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: ☐A04.04.19☐New issue☐KJ/JLM☐

IPP: B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3278-1

Manufactured No

100

Each

41.0000

1

30



Support

Location

Loc Qty

Loc Code

ST045

34

60564

4

61194

30

ST048

7

51353

7



EP 10/10/06

30

D3278-2

Manufactured No

100

Each

39.0000

1

30



Support

Location

Loc Qty

Loc Code

ST045

30

61195

30

ST048

9

60565

9



EP 10/10/06

30

D3278-3

Manufactured No

100

Each

104.0000

1

30



Spacer

Location

Loc Qty

Loc Code

ST045

87

60244

87

ST049

17

60081

17



EP 10/10/06

13

17

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 62395

Parent Item: D3278-041


Parent Item Name: Support Assembly

Start Date: 9/29/2010


Required Date: 10/21/2010

Start Qty: 30.00


Required Qty: 30.00

MS21042L4 Purchased No 100 Each 4,498.000 2 60

 Nut

Location	Loc Qty	Loc Code
ST300	4498	
113422	68	
114523	8	
114718	16	
114784	32	
115108	1374	
115589	1900	
115621	1100	


AN4-13A Purchased No 120 Each 480.0000 2 60

 Bolt

Location	Loc Qty	Loc Code
ST358	480	
115159	480	

AN960JD416 NAS1149D0463J Purchased No 120 Each 24.0000 4 120

 Washer

4 M115622 (120x)

Location	Loc Qty	Loc Code
ST300	24	
113288	24	

D2230-1 Manufactured No 120 Each 87.0000 2 60

 Lug

Location	Loc Qty	Loc Code
ST476	87	
60289	27	
61713	60	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 62395



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 9/29/2010

Required Date: 10/21/2010

Start Qty: 30.00

Required Qty: 30.00

MS20426AD3-6

Purchased

No

120

Each

1,450.000

4

120



Rivet

Location

Loc Qty

Loc Code

ST316

1450

105055

1450

Handwritten signature
120

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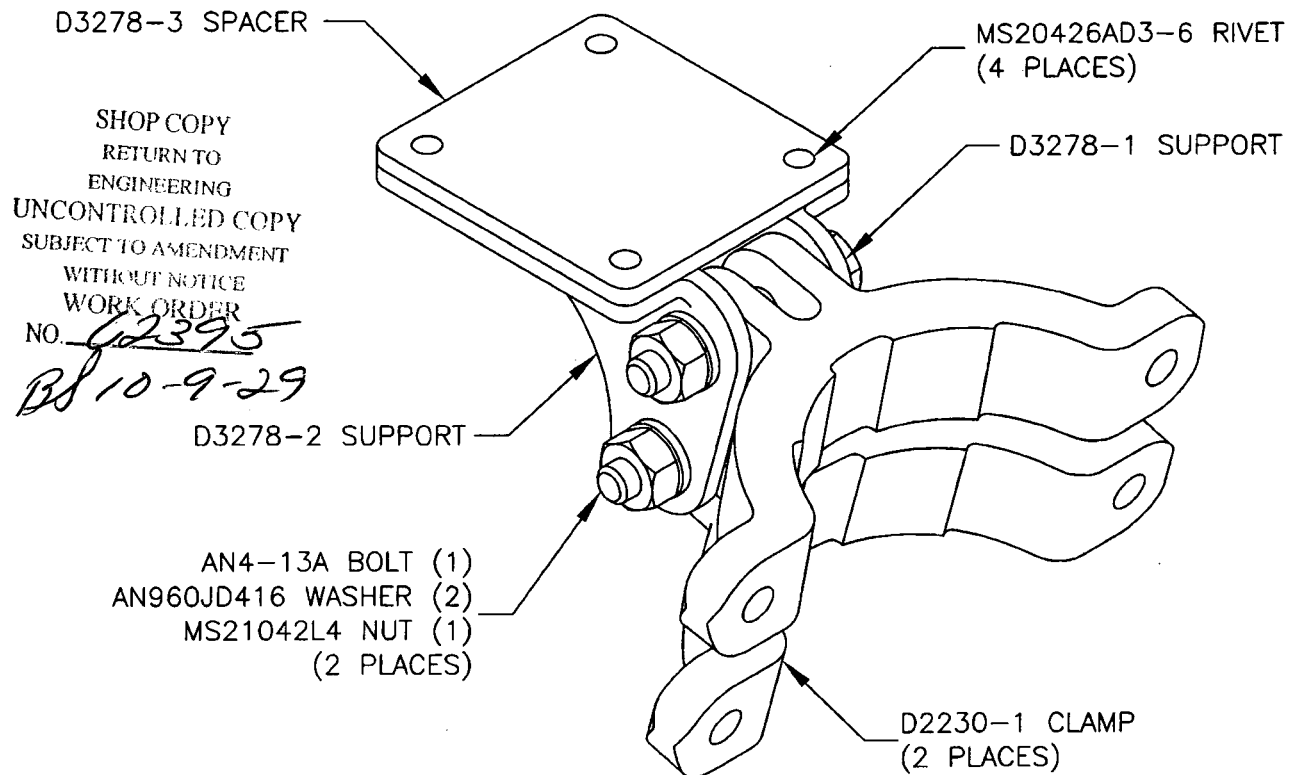
NOTE: Date & initial all entries

DART

DESIGN 99	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

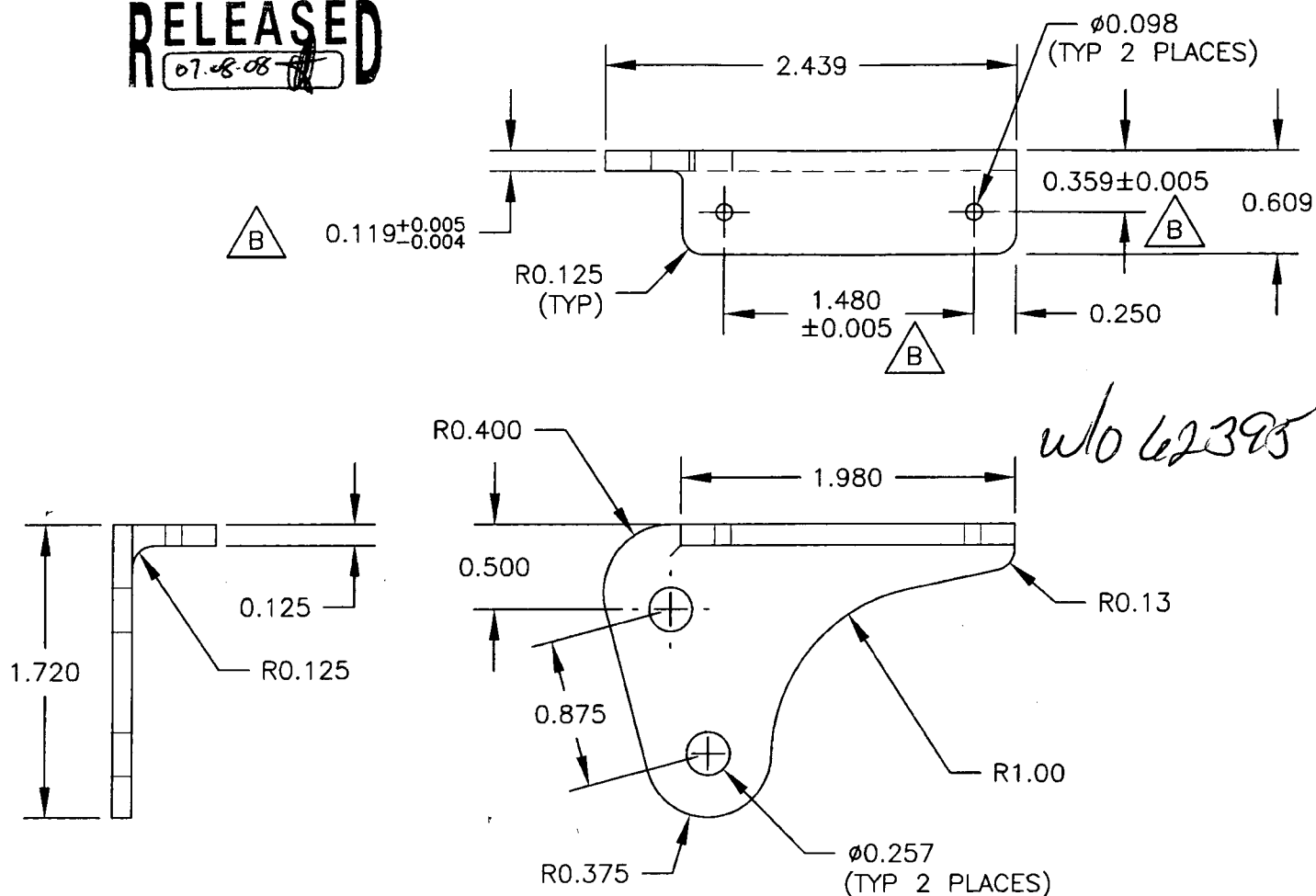
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DESIGN <i>qp</i>	DRAWN BY <i>dc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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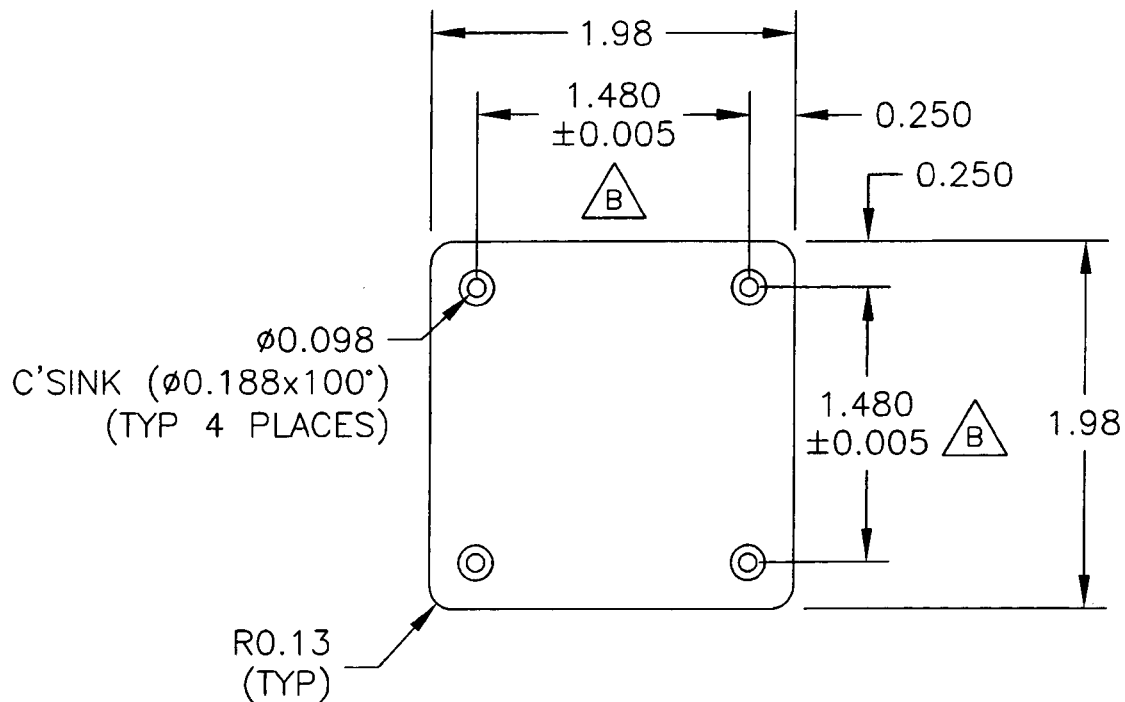
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DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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